

Date: Tuesday, 12/20/2005 9:44:55 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206B BASKET BASE
<b>Job Number</b> : 22087B	
<b>Estimate Number</b> : 11276	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2330041
<b>This Issue</b> : 12/20/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : E
<b>Previous Run</b> :	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 1/30/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SEE ABOVE USER &amp; DATE</u>	
<b>Comment</b> : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D31661	Basket Hoop
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part#

Description

Batch

4 ~~1~~ D3166-1

Hoop

Babasa (2) B25844 (2) PD

06-04-05

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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**Comment:** Qty.: 25.3019 f(s)/Unit Total: 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M100S60

PD

06-04-05

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

PD

06-04-05

4.0	D22531	Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2253

Gusset

B12413

PD

06-04-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2012-107	Clevis	
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~~B25483~~ B25483

PD

06-04-05

6.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2327-3	Bushing	
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B25323

PD

06-04-05

7.0	D2581	Mounting Bracket
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D2581	Mounting Chancel	
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B25834(3) B26204(1)

PD

06-04-05

8.0	D2254	Gusset for D206bskt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2254	Lug	
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B23421

PD

06-04-05

9.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2232-3	HINGE	
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B25239

PD

06-04-05

10.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2012-107	CLEVIS	
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~~B25483~~ B25483

PD

06-04-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: SD Date: 06/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

M100518

PD

06-04-11

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M19555

PD

06-04-11

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

NA 06/04/11

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/13 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 13 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/04/20

Job Completion



06.04.20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

5104

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description: 206B Basket Base</b>	<b>Part Number:</b>	<b>D2330-041</b>
<b>D1</b>		
<b>Drawing: D2330 Rev. <del>D</del> Pages 1,3,4 &amp; 5</b>	<b>Qty:</b>	<b>1</b>

R04.0623

Step	Location	Procedure	By	Date	Qty																												
1	DC	Open Traveller <b>Dwg not required</b>	<i>[Signature]</i>	04.12.14	1																												
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: _____  Cut Qty. 4 D2235-1 from: Qty. 4 D3166-1 Batch: _____																															
3	WS	Drill hole in D2330-3 as per Dwg D2330																															
4	WS	Deburr																															
5	WS <i>RF 02/09/10</i>	Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2253-1</td><td>Gusset</td><td>_____</td></tr><tr><td>1</td><td>D2012-107</td><td>Clevis</td><td>_____</td></tr><tr><td>1</td><td>D2327-3</td><td>Bushing</td><td>_____</td></tr><tr><td>4</td><td>D2581</td><td>Mounting Chanel</td><td>_____</td></tr><tr><td>2</td><td>D2254</td><td>Lug</td><td>_____</td></tr><tr><td>30 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td>_____</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2253-1	Gusset	_____	1	D2012-107	Clevis	_____	1	D2327-3	Bushing	_____	4	D2581	Mounting Chanel	_____	2	D2254	Lug	_____	30 sf	M304EX0.75-16F	Expanded Metal	_____			
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2	D2253-1	Gusset	_____																														
1	D2012-107	Clevis	_____																														
1	D2327-3	Bushing	_____																														
4	D2581	Mounting Chanel	_____																														
2	D2254	Lug	_____																														
30 sf	M304EX0.75-16F	Expanded Metal	_____																														
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required																															
7	QC9 & 6	Inspect Welding and Dimensions																															
8	WS	Take Traveller D206-540-013 to KP																															
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3																															
10	QC3	Inspect Powder Coat																															
11	FP	To Miscellaneous Cell for Assembly																															

Rev	Date	Change	Revised By	Approved
B	94.12.03	/		JB
C	99.09.17	Re-format (was lpp-341B)	EC	
D	99.12.14	Re-format, Added Clevis to pick list	EC	
E	00.02.03	Re-format, Added Rib to pick list	EC	
F	00.06.26	Removed P/O for powder coat	EC	
G	02.07.23	Re-format added D3166-1; Modify Step 1	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	<i>[Signature]</i>

RELEASED  
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_